

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001427**Date Inspected:** 23-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No			
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG				

**Summary of Items Observed:**

This Quality Assurance Inspector reviewed the radiographic film for three OBG bottom plate complete joint penetration welds accepted by quality control. During the review one of the welds was found to be unacceptable and Mr. Kevin Carpenter of American Bridge / Fluor was notified. Mr. Carpenter who had also reviewed the film came to the Quality Assurance Office to reread the film and agreed with the quality assurance call. An Incident Report was written and submitted by this Quality Assurance Inspector. For details see Radiographic Report TL-6029 dated January 23, 2008.

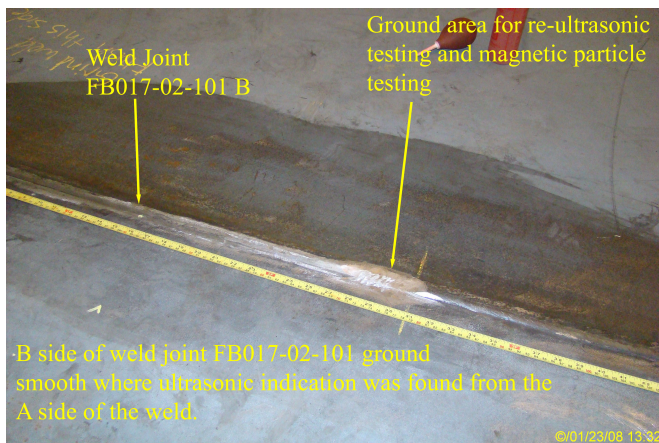
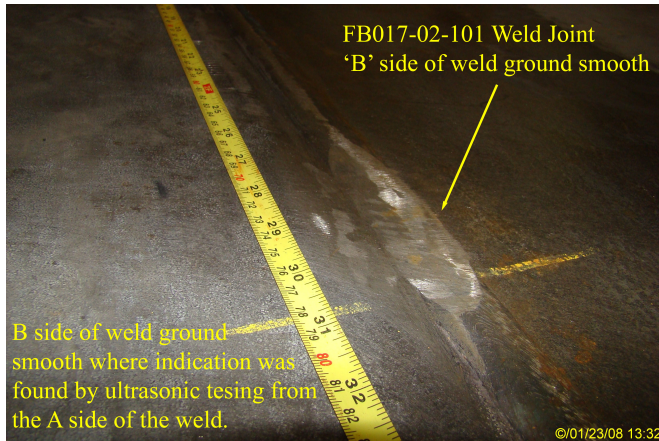
This Quality Assurance Inspector performed magnetic particle testing on transition weld joint FB017-02-101 after transition side of the weld was ground smooth. Ultrasonic testing had found a recordable indication during examination both before and after contouring of the weld. The indication appeared to be a one half skip distance or the depth of the plate running the full length of the weld. Magnetic Particle Testing was carried out in both the AC & DC mode with the primary direction of inspection looking for longitudinal indications. No indications were observed so the probable cause of the indication is suspected to be weld geometry. For detail see magnetic particle testing report TL-6028 dated January 23, 2008.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

A conversation was held with Mr. Kevin Carpenter of American Bridge/Fluor concerning Zhenhua Port Machinery Company radiographic reports. It was pointed out to Mr. Carpenter that there were several items missing from the report, one of which is the acceptance criteria being used. It was mentioned that the radiographic report should specify which figure or table is being used for acceptance.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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**Inspected By:** Berger,Bruce

Quality Assurance Inspector

**Reviewed By:** Cochran,Jim

QA Reviewer

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